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RBST2812-P
Job Sheet 198883



Part No: RBST2812-P

Job Qty: 2 pcs

Part Name: Portable Tri-Roller Staking Tool



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/7/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 10/3/19

Description:

Type: SOLD

Note: DWG RBST2800-P Rev. 1 IPP Rev. A 18.06.21 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Sign-off
100	Small Fab - 1	2 pcs		10/3/19	0.00	1.00	Small Fab - 1	
							Small Fab - 2	
							Small Fab - 3	
							Small Fab - 4	
							Small Fab - 5	
							Small Fab - 6	
							Small Fab - 7	
							Small Fab - 8	
110	QC 5	2 pcs		10/3/19	0.00	0.00	QC 5 - 10	
							QC 5 - 12	
							QC 5 - 17	
							QC 5 - 18	
							QC 5 - 19	
							QC 5 - 22	
							QC 5 - 24	
							QC 5 - 3	
							QC 5 - 43	
							QC 5 - 49	
							QC 5 - 51	
							QC 5 - 58	
							QC 5 - 68	
							QC 5 - 9	
							QC 5 - 50	
							QC 5 - 30	
							QC 5 - 40	
							QC 5 - 61	
							QC 5 - 81	
130	Packaging 3-1 - Stock - B4B	2 pcs		10/3/19	0.00	0.00	Packaging 3 - 1 - B4B	
							Packaging 3 - 2 - B4B	
							Packaging 3 - 3 - B4B	
							Packaging 3 - 4 - B4B	



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Container No: S215545



Part: RBST2812-P

Job No: 198883

Serial No/Batch: S215545

Revision: 1

Inspector:

Exp Date:

Instructions:

Date: 09/20/19

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				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - FG		2 pcs	10/3/19	0.00 0.00	QC 21 - FG - 21
closed wo 92					QC 21 - FG - 70
					QC 21 - SA - 53

SEP 23 2019

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GA 138

Part Op 100 - (Small Fab) 1-Assemble as per DWG sheet 1. ***NOTE*** - Apply a light coat of corrosion prevention compound to Descriptions: assembly (LPS 1/2) See deviation. See note 1 and 2.
 110 - QC5- Inspect part completeness to step on W/O
 130 - (Identify as per dwg & Stock Location: _____) Identify and Stock
 140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
54 92383A202	Roll Pin	2 pcs (1 ea)	100-Small Fab - 1	5089124
58 95065A150	Distorted Thread Lock Nut	2 pcs (1 ea)	100-Small Fab - 1	5089130
43 99142A410	Internal Snap Ring	2 pcs (1 ea)	100-Small Fab - 1	5089125
98 CS075-H1	Crest to Crest Flat Wire Wave Spring	2 Ea (1 ea)	100-Small Fab - 1	5093424
34 NTA-411	Bearing	2 Ea (1 ea)	100-Small Fab - 1	5032972
34 NTA-613	Bearing 13/16" Od X 3/8" Id (Applied)	2 Ea (1 ea)	100-Small Fab - 1	5071979
137 RBST2812-P-1	Base	2 pcs (1 ea)	100-Small Fab - 1	5121008
RBST2812-P-11	Dual Seat	2 pcs (1 ea)	100-Small Fab - 1	5122412
RBST2812-P-13	Receiver	2 pcs (1 ea)	100-Small Fab - 1	5121969
RBST2812-P-15	Tensioner	2 pcs (1 ea)	100-Small Fab - 1	5122915
RBST2812-P-3	Retainer	2 pcs (1 ea)	100-Small Fab - 1	5119966
RBST2812-P-5	Roller	6 pcs (3 ea)	100-Small Fab - 1	5212510
RBST2812-P-7	Cap	2 pcs (1 ea)	100-Small Fab - 1	5119984
137 RBST2812-P-9	Stud	2 pcs (1 ea)	100-Small Fab - 1	5122419
36 TRA-411	Washer	4 Ea (2 ea)	100-Small Fab - 1	5150492
36 TRA-613	Washer 13/16" Od X 3/8" Id (Applied)	4 Ea (2 ea)	100-Small Fab - 1	5150492

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Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	92383A202	2	93	0
	95065A150	2	91	0
	99142A410	2	45	0
	CS075-H1	2	4	0
	NTA-411	2	34	0
	NTA-613	2	4	0
	RBST2812-P-1	2	4	0
	RBST2812-P-11	2	5	0
	RBST2812-P-13	2	4	0
	RBST2812-P-15	2	4	0
	RBST2812-P-3	2	4	0
	RBST2812-P-5	6	2	0
	RBST2812-P-7	2	4	0
	RBST2812-P-9	2	4	0
	TRA-411	4	62	0
	TRA-613	4	20	0
Part Specifications				
Specifications could not be found.				

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REV		REVISIONS	DATE	INITIAL	APPROVED
1	CH'D -1, -3, -9, -11 & -13 DATUM TARGET DESIGNATIONS AND FEATURE CONTROL FRAMES. ADDED 2ND FLAT ON -13.		7/26/12	RUC	SE

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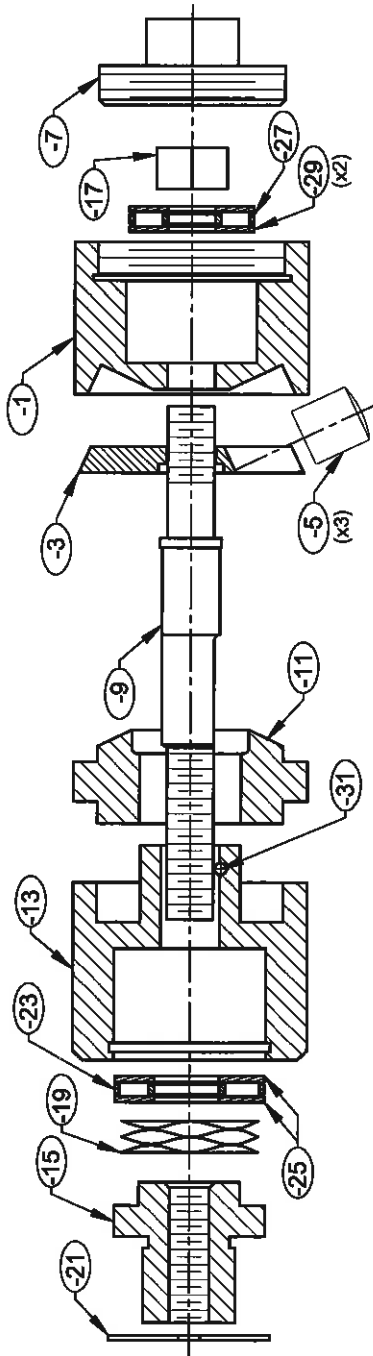
WITHOUT NOTICE

WORK ORDER

NO. 198883

hcs

19-08-07



NOTES

1. -5 ROLLERS AND -3 RETAINER MUST TURN SMOOTHLY ON -1 BASE WHEN ASSEMBLED.
2. FLAT END OF -5 ROLLERS MUST FACE THE CENTER OF TOOL WHEN ASSEMBLED.

ASSY QTY	BOI	PART #	UNIT	DESCRIPTION	MAT.	B/O INFORMATION OR SPECIFICATIONS	Pg.
		-1	1	BASE		SEE CHART	2
		-3	1	RETAINER		SEE CHART	3
		-5	3	ROLLER		SEE CHART	4
		-7	1	CAP		SEE CHART	5
		-9	1	STUD		SEE CHART	6
		-11	1	DUAL SEAT		SEE CHART	7
		-13	1	RECEIVER		SEE CHART	8
		-15	1	TENSIONER		SEE CHART	9
		-17	1	DISTORTED THREAD LOCK NUT	STEEL	1/4-20 UNC x 7/32 HL McMaster-Carr #95085A150	1
		-19	1	CREST TO CREST FLAT WIRE WAVE SPRING	STEEL	.750 OD, .550 ID, WIRE THICK. .013, THREE TURNS SMALLER RING CO. #CS975-H1	1
		-21	1	INTERNAL SNAP RING	STEEL	.078 BORE McMaster-Carr #98142A410	1
		-23	1	THRUST BEARING (SPRING SIDE)	STEEL	.038 ID. x .13/16 OD. x .564 WIDTH APPLIED (TIMKEN #NTA-513)	1
		-25	2	BEARING WASHER	STEEL	.038 ID. x .13/16 OD. x .132 WIDTH APPLIED (TIMKEN #TRA-513)	1
		-27	1	THRUST BEARING	STEEL	.014 ID. x .11/16 OD. x .564 WIDTH APPLIED (TIMKEN #NTA-411)	1
		-29	2	BEARING WASHER	STEEL	.014 ID. x .11/16 OD. x .132 WIDTH APPLIED (TIMKEN #TRA-411)	1
		-31	1	ROLL PIN	STEEL	.03/32 x 3/8	N/S

BEARINGS & TOOLS COVERED	
BEARING #	TOOL #
208-010-470-101	RBST2812-P

RED BARN MACHINE

RBST2800-P SERIES FOR BELL BEARINGS
PORTABLE TRI-ROLLER SWAGING TOOLS

DWG NO.	REV
SEE CHART ABOVE FOR TOOL NO. 1	1
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON:	
DECIMALS	FRACTIONS ± 1/32
.XXX ± .005	ANGLES ± 5°
.XX ± .01	
.X ± .1	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 X .4375 R .015	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE	DATE
NTS	11-9-09
SHEET	1 of 9

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only



Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Cross tube ☐ Skid-tube ☐ Eng. (Non-AW) ☐ Small Fab ☐ Machining ☐ Prod. Eng. Coord. ☐ Finishing ☐ Large Fab ☐ Rec/Store/Packaging ☐				Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date: _____		Sequence #: _____		QTY Affected: _____		MRB (QS1042)					
Description Work Order Deviation				Disposition							
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				FAULT CATEGORY							
				Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐		Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐		Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐	
				Other/Details: _____							
Completed By				Lead hand / Supervisor							
QC / QA Coordinator											